

202382

Work Order ID 69309

Monday, May 09, 2011 7:45:27 AM

Page 1

Item ID: D4370-043

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Aft Wearplate Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Required Date: 5/12/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: AA

Date: 11.05.09

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4370

PA2

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4370-3)

Dwg Rev: PA2

Prog Rev: PA2

2-Deburr if necessary

①

B11-5-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00






Quality Control



B11-5-10




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Page 2

Item ID: D4370-043 Accept  Setup Start 
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Item Name: Aft Wearplate Assembly
Start Date: 5/9/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/12/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	- inspector to Par Dry only 8/11/10 @						
130  Brake NC Brake NC	Form as per dwg Memo *** Jigs DT8261 and DT8326 ***	0.00 0.00				①			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	- inspector to Par Dry only 8/11/10 @						



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Page 3

Item ID: D4370-043 Accept  Setup Start 
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Start Date: 5/9/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/12/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Large Fab	Memo 1- on D4371-3, fill cut outs with hardcoat welding rod as per dwg D4370 **DT9756** 2059 B Hardcoat Welding Rod BATCH#: <u>M11-7659</u> 2-weld D4371-3 to wearplate by positioning holes together as per dwg D4370 304 S.S. Welding Rod BATCH#: <u>M107051</u> 3-Transfer drill holes in bar	0.00 0.00		x1		12/7/11	11-06-09		
160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							 11-06-10

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Item ID: D4370-043 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Aft Wearplate Assembly
Start Date: 5/9/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/12/2011 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>inspected to PAA</i> <i>Day only</i> <i>8/10/10</i>					
180  Small Fab Small Fab	Memo 1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4370. <i>coat inside surface using Plus 1 Rockguard</i> <i>4715 Black</i>	0.00 0.00						<i>11-06-13</i>	
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						<i>11 06 13</i>	<i>(1)</i>

Picklist Print

Page 1

Monday, May 09, 2011 7:45:24 AM

Work Order ID: 69309

Parent Item: D4370-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 5/9/2011


Required Date: 5/12/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4371-3		Manufactured	No			150	Each	1.0000	1	1			
													
Bar													

Location Loc Qty Loc Code

WA	1	
68410	1	

M304S18GA		Purchased	No			100	sf	122.5000	2.162	2.275789			
													
304/316 .050 Sheet													

Location Loc Qty Loc Code

MAT020	122.5	
112178	4	
113062	18	
116135	26	
116604	5.5	
116979	69	

~~11-06-08~~ JRL

1

11-5-10

116135

①

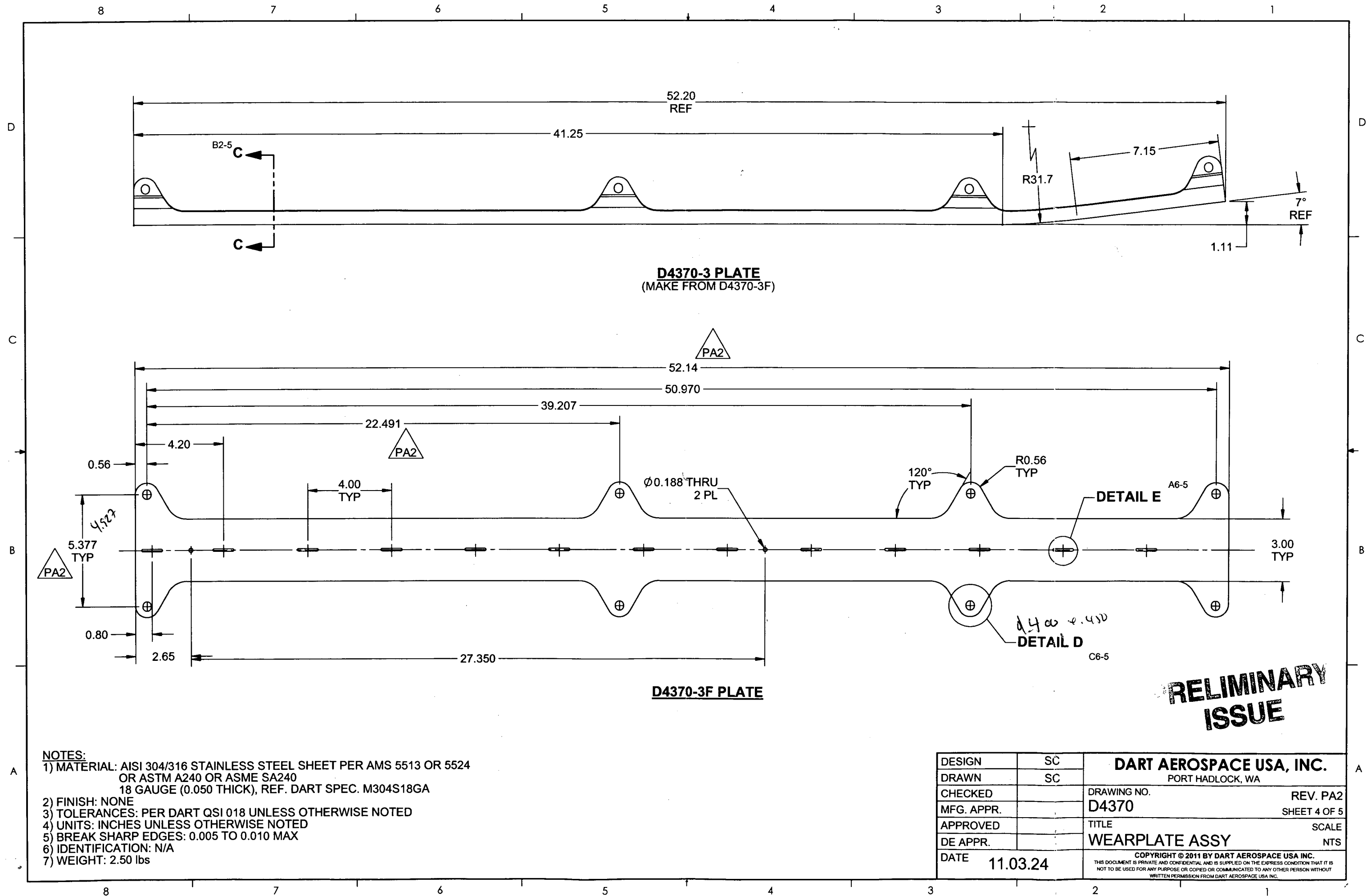
DART AEROSPACE LTD		Work Order: 69309
Description: AFT WEAR PLATE		Part Number: D4370-042
Inspection Dwg: D4370-3, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

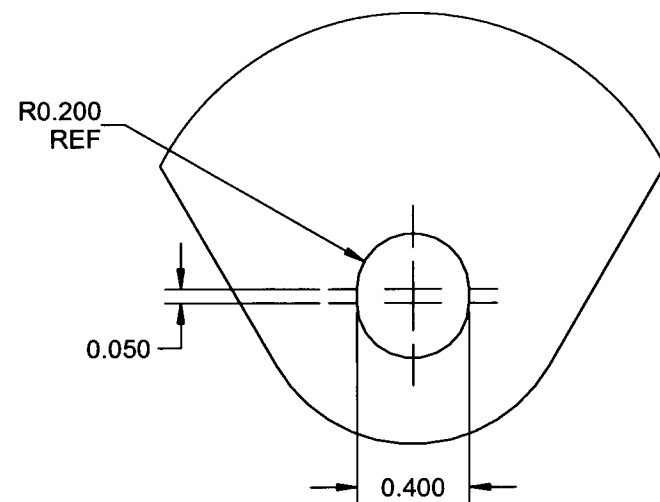
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.88	+0.005 - .001	1.90	✓		V HB02	
.56	±.030	.560	✓		V	
.80	±.030	.800	✓		V	
2.65	±.030	2.650	✓		V	
4.20	±.030	4.200	✓		V	
4.00	±.030	4.003	✓		V	
3.00	±.030	3.008	✓		V	
.400	±.010	.401	✓		V	
.050	±.010	.050	✓		V	
.125	±.010	.128	✓		V	
.875	±.010	.875	✓		V	
22.491	±.010	22.491	✓		T HB02	
39.207	±.010	39.207	✓		T	
50.970	±.010	50.970	✓		T	
52.14	±.030	52.140	✓		T	
27.350	±.010	27.350	✓		T	
.050	±.010	.047	✓		V	

Measured by: HB	Audited by: S	Prototype Approval:
Date: 11-5-16	Date: 11/05/16	Date:
to PA2 Dwg only		
Rev A	Date	Change
		New Issue
Revised by: KJ/JLM	Approved	

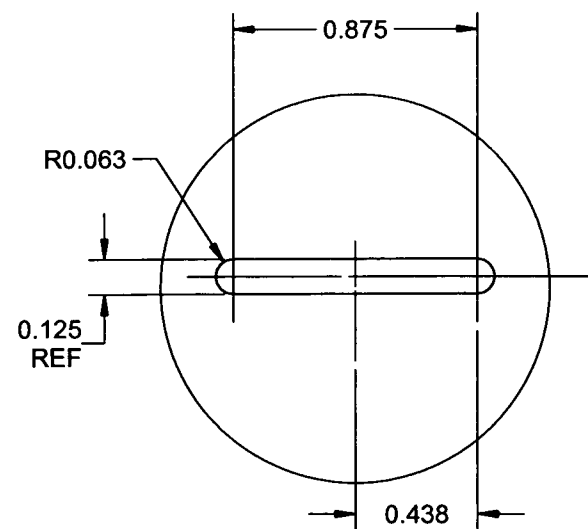


- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.50 lbs

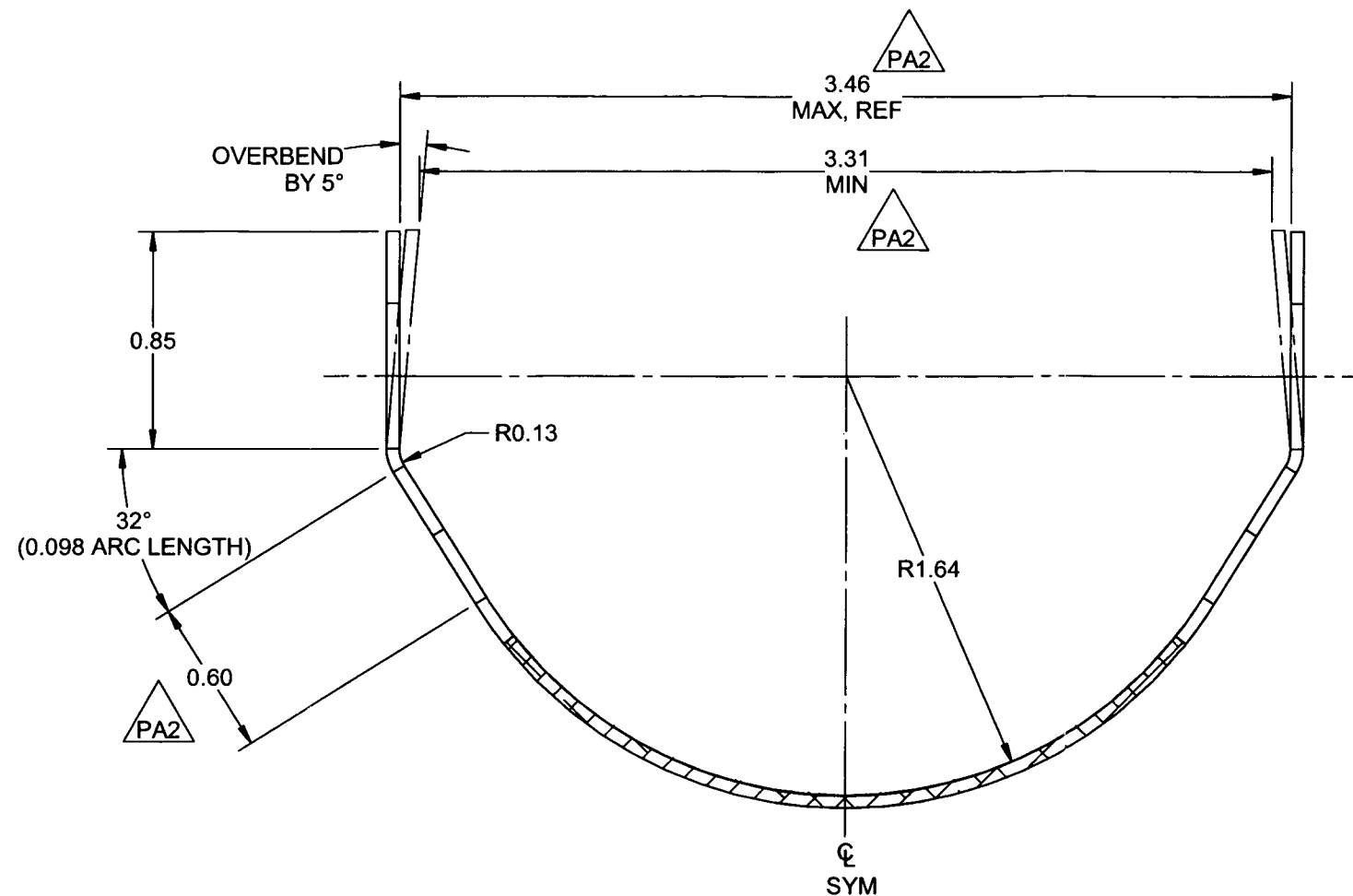
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO. D4370	REV. PA2
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.	
DATE	11.03.24		



DETAIL D
SLOT DETAIL TYP
B3-3
B2-4



DETAIL E
SLOT DETAIL TYP
B5-3
B1-4



SECTION C-C

D3-3
D7-4

**PRELIMINARY
ISSUE**

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4370	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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